



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-122
Job Sheet 197985



Part No: D350-591-122

Job Qty: 5 pcs ✓

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 8/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2351-042 REV E, IIN-D350-591 REV H IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF

Shlp Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs		
110	Large Fab - Steps - 1	5 pcs	8/13/19		0.00	4.00	Large Fab - 1	SLY
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
120	Skidtubes - Bend - 2 - B4B	5 pcs	8/13/19		0.50	1.25	Skidtubes - Bend - B4B	ATW
122	QC 5	5 pcs	8/13/19		0.00	0.00	QC 5 - 10	BAG 24 9-89 AUG 20 2019
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	

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				QC 5 - 81	
126 Large Fab - Steps - 2 - B4B	5 pcs	8/13/19	0.00 5.62	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	CL
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				QC 5 - 10	
				QC 5 - 12	
130 QC 5	5 pcs	8/13/19	0.00 0.00	QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 10	
				QC 5 - 12	
140 Large Fab - Welded Assy-2-B4B	5 pcs	8/13/19	0.00 4.17	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	CL
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				QC 9 - 10	
				QC 9 - 18	
150 QC 9	5 pcs	8/13/19	0.00 0.00	QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
160 QC 5	5 pcs	8/13/19	0.00 0.00	QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

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				QC 5 - 49					
				QC 5 - 51					
				QC 5 - 58					
				QC 5 - 68					
				QC 5 - 9					
				QC 5 - 50					
				QC 5 - 30					
				QC 5 - 40					
				QC 5 - 61					
				QC 5 - 81					
				170 Handfinish - 1-1 Chemical-B4B	5 pcs	8/13/19	0.00 0.50	Handfinish - 1 - 1 - B4B	BEB19-0820
Handfinish - 1 - 2 - B4B									
Handfinish - 1 - 3 - B4B									
Handfinish - 1 - 4 - B4B									
Handfinish - 1 - 5 - B4B									
Handfinish - 1 - 6 - B4B									
Handfinish - 1 - 7 - B4B									
Handfinish - 1 - 8 - B4B									
Handfinish - 1 - 9 - B4B									
Handfinish - 1 - 10 - B4B									
Handfinish - 1 - 11 - B4B									
Handfinish - 1 - 12 - B4B									
Handfinish - 1 - 13 - B4B									
Handfinish - 1 - 14 - B4B									
Handfinish - 1 - 15 - B4B									
Handfinish - 1 - 16 - B4B									
Handfinish - 1 - 17 - B4B									
Handfinish - 1 - 18 - B4B									
Handfinish - 1 - 19 - B4B									
Handfinish - 1 - 20 - B4B									
Handfinish - 1 - 21 - B4B									
Handfinish - 1 - 22 - B4B									
180 QC 7	5 pcs	8/13/19	0.00 0.00					QC 7 - 10	
				QC 7 - 13					
				QC 7 - 14					
				QC 7 - 15					
				QC 7 - 17					
				QC 7 - 18					
				QC 7 - 19					
				QC 7 - 2					
				QC 7 - 28					
				QC 7 - 3	AUG 21 2019				
				QC 7 - 30					
				QC 7 - 34					
				QC 7 - 36	DAS 24 8-89				
				QC 7 - 37					
				QC 7 - 41					
				QC 7 - 47					
				QC 7 - 48					
				QC 7 - 51					
				QC 7 - 58					
				QC 7 - 59					
				QC 7 - 60					
				QC 7 - 9					
				QC 7 - 68					
				QC 7 - 50					
				QC 7 - 67					
				QC 7 - 40					
				QC 7 - 24					
								Plex 7/19/19 10:43 AM Dart.lajeunesse.marie	

190 Large Fab - Welded Assy-3-B4B	5 pcs	8/13/19	0.00 4.00	QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	LL
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
220 QC 10	5 pcs	8/13/19	0.00 0.00	Large Fab - 11 - B4B (Various)	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
230 QC 5	5 pcs	8/13/19	0.00 0.00	QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
240 Handfinish - 1-2- Chemical-B4B	5 pcs	8/13/19	0.00 0.94	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	BEB 19-08-22
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	

					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
250 Powdercoat - 1 White GI(A)- B4B	5 pcs	8/13/19	0.00 1.03		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
260 Handfinish - 3-1- WingWalk- B4B	5 pcs	8/13/19	0.00 0.94		Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
270 QC 3	5 pcs	8/13/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
280 Packaging 1-1 - Pick Kit - B4B	5 pcs	8/13/19	0.00 0.00		Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	

BL 17-8-22

HL 19-8-22

DAS
40
9-89

AUG 23 2019

					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36	
					QC 4 - 28	MUL 8/23/2019
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
290 QC 4	5 pcs	8/13/19	0.00	0.00	QC 4 - 75	
300 Packaging 3-1 - Stock - B4B	5 pcs	8/13/19	0.00	0.00	Packaging 3 - 1 - B4B	MUL 8/23/2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
305 DC - 1 - B4B	5	8/13/19	0.00	0.00	DC - 1 - B4B	AUG 26 2019

310 QC 21 - FG	pcs	5	8/13/19	0.00 0.00	DC - 2 - B4B	
	pcs				QC 21 - FG - 21	DAS
					QC 21 - FG - 70	70
					QC 21 - SA - 53	9-89

AUG 26 2019

Part Op 110 - Fabricate per Drwg - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup
Description: DT8185-G

120 - CNC Delta 100 Bender - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041

122 - QC5- Inspect part completeness to step on W/O

126 - Fabricate per Drwg) ***BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer***

130 - QC5- Inspect part completeness to step on W/O

140 - Weld per dwg A/R Aluminum rod Batch: 138872 1-Bevel Fwd and Aft end for welding

150 - QC9- Inspect visual per QSI004- Fusion Welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1

180 - QC7-Inspect Chemical Conversion Coat

190 - Weld per dwg A/R Aluminum rod Batch: 138872 - 1-Rivet Leg Assembly as per Dwg D2351

220 - QC10- Inspect visual per QSI004- ground welds

230 - QC5- Inspect part completeness to step on W/O

240 - Chemical Conversion Coat per QSI005 4.1

250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

260 - Wing Walk as per dwg QSI005 4.4 Batch: 5185147

270 - QC3- Inspect Part Finish

280 - Pick Kit

290 - QC4- 100% Inspect kits for completeness

300 - Identify and pack for shipping as per PPP D350-591-121

305 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

310 - QC21- Final Inspection - Work Order Release - 3-Do not Grind top edge Flush

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2,5000 pcs (5 ea)	110-Large Fab - Steps - 1	5081118
D2850-2	End Cap	5 pcs (1 ea)	126-Large Fab - Steps - 2 - B4B	6065609
D2582	Hi-Skid Step Leg Assembly	5 pcs (1 ea)	190-Large Fab - Welded Assy-3- B4B	5208065
D2673-34	End Plate	5 pcs (1 ea)	190-Large Fab - Welded Assy-3- B4B	5192727 / 1614321
MS20600-AD4W3	Cherry Rivet	80 Ea (16 ea)	190-Large Fab - Welded Assy-3- B4B	5196544
AN3-37A	Bolt	10 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
AN3-13A	Bolt	5 Ea (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
AN4-16A	Bolt	10 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
D2230-1	Mounting Lug	5 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
D2230-3	Mounting Lug	5 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
D2732-030	Rubber Cushion - 3"	10 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
MS21042L3	Nut	10 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
MS21042L4	Nut	15 Ea (3 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
NAS1149D0363J	Washer	20 Ea (4 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544
NAS1149D0463J	Washer	30 Ea (6 ea)	280-Packaging 1-1 - Pick Kit - B4B	5196544

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	3	5	0
126-Large Fab - Steps - 2 - B4B	D2850-2	5	7	0
190-Large Fab - Welded Assy-3- B4B	D2582	5	3	0
	D2673-34	5	69	0
	MS20600-AD4W3	80	928	0
280-Packaging 1-1 - Pick Kit - B4B	AN3-37A	10	83	0
	AN4-13A	5	1,446	0
	AN4-16A	10	1,146	0
	D2230-1	5	186	0
	D2230-3	5	759	0
	D2732-030	10	488	0
	MS21042L3	10	1,037	0
	MS21042L4	15	3,016	0
	NAS1149D0363J	20	1,404	0
	NAS1149D0463J	30	4,298	0

Part Specifications
Specifications could not be found.

Plex 7/19/19 10:43 AM Dart.lajeunesse.marie

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐							
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Presservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
Completed By				Lead hand / Supervisor				QC / QA Coordinator			

Change Record

PAGE 1 OF 1

Part Number: D350-591-122

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, RH

[illegible]

Michelle GagnonDonovan

From: Shipping
Sent: Friday, August 23, 2019 1:58 PM
To: Michelle GagnonDonovan; Jennifer Renwick
Subject: Red Label

Please provide a red label for the following work order

D350-591-122
Job#197985
Serial#S205993

Make sure who is making those label so it doesn't get printed twice .

thank a lot !

Mickael

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3695-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT